

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022237**Date Inspected:** 15-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:****Bay 1**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 1 ZPMC was in process of welding and heat straightening on Re-Built traveler rail assemblies. ZPMC QC inspector Zhang Ya Xu was present at this time of this observation and informed this QA inspector of the work that is in process and identified Li Zhi Jiang as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20369 (Rev.0)

Weld- 20TR2-044-011

WPS-345-SMAW-1G(1F)-Repair

Welder-049769

1G/CJP/SMAW

Heat Straightening

HSR (B) 461

20TR2-036-009, 013, 015, 017, 011

Caltrans Stamped Approved

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted

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that at Bay 10 ZPMC was in process of welding. ZPMC CWI inspector Li Jun was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 10 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20423 (Rev.0)

Weld- BK015B-001-017, 020, 019

WPS-345-SMAW-1G(1F)-Repair

Welder- 057220, 040582

1G/SMAW/CJP

WR20424 (Rev.0)

Weld- BK015A-001-011, 013

WPS-345-SMAW-3G(3F)-Repair

Welder- 040365, 040581

1G/SMAW/CJP

Weld- BK014A5-001-032

WPS-B-P-221-B-U2

Welder- 057238, 044511

1G/SMAW/CJP

Weld- BK014A5-001-028

WPS-B-P-221-B-U2

Welder- 500363

1G/SMAW/CJP

Weld- BK014A3-001-011

WPS-B-P-221-B-U2

Welder- 053829

1G/SMAW/CJP

Weld- BK014A3-001-013

WPS-B-T-2232-ESAB

Welder- 047353

2G/FCAW/CJP

Weld- BK009A8-001-036, 037

WPS-B-T-2133-ESAB

Welder- 040302

3F/FCAW

Bay 11

This QA inspector performed a random observation for the OBG. During the observation performed it was noted

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that at Bay 11 ZPMC was in process welding. ZPMC QC inspector Xu Jie was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhao Chen Shun as the CWI. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Tower Head Cover
Weld-ESD1-TL6-2C/D-19
WPS-B-P-2314-TC-P4
Welder- 040609
4G/SMAW/PJP

WR20430 (Rev.0)
Weld-BK008ASD1-002-024
WPS-345-SMAW-4G(4F)-Repair
Welder- 202354
4G/SMAW/CJP

Trial Assembly

This QA inspector observed ZPMC in process of SMAW welding on Lift 12 segment assemblies. ZPMC CWI inspector Zhu Zhong Hai was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

12CW
Weld- CA3010E-092
WPS-B-P-2114-FCM-1
Welder- 057333
4F/SMAW

MT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08552 from ZPMC for segment 12AE trial assembly. This QA inspector performed visual and magnetic particle test (MT) verification for Item 1, 2 after ZPMC had performed their MT inspection of the following locations;

Item 1
SEG3001N-001, 002
Item 2
SEG3001K-001, 002

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Magnetic Particle Test Report (TL6028), dated 03-15-2011 for additional information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
